

use for Blue

Work Order ID 53350

November 2, 2009 10:42:03 AM



Page 1

Item ID: D3407-3

Accept



Setup Start



Revision ID: E

Stop



Item Name: Stem

Start Date: 02/11/2009 Start Qty: 20.00



Cust Item ID:

Required Date: 13/11/2009 Req'd Qty: 20.00



Customer:

Reference:

Approvals:

Process Plan:

PS

Date: *09-11-2*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3407

Rev E

100

0.00

09.11.05

21

0



DOOSAN LATHE

Doosan

Memo

0.00

Doosan Lathe

1-Turn as per Folio FA597 Rev: *11* & Dwg D3407 Rev: *E* □ 2-Deburr

110

0.00

09.11.05

21

0



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

120

0.00

SAOV 11/08

21

0



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

Work Order ID 53350

November 2, 2009 10:42:03 AM



Page 2

Item ID: D3407-3

Accept



Setup Start



Revision ID: E

Stop



Item Name: Stem

Start Date: 02/11/2009 Start Qty: 20.00



Cust Item ID:

Required Date: 13/11/2009 Req'd Qty: 20.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

Welding for

0.00

D3407-043 B53351 Blue

U 09.11.09

21

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/11/09

PH/09-11-9

Picklist Print

November 2, 2009 10:42:07 AM

Page 1

Work Order ID: 53350

Parent Item: D3407-3RevE

Parent Item Name: Stem

Comments:

Start Date: 02/11/2009

Required Date: 13/11/2009

Start Qty: 20.00

Required Qty: 20.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

M174R0.750

Purchased

No

100

f

36.4500

7.7053



17-4 round bar .750

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

36.45

110777

12.25

112998

24.2

Handwritten: 11-05-09, 94.2", 7.85'

2'

DART AEROSPACE LTD		Work Order:	53350
Description: Stem		Part Number:	D3407-3
Inspection Dwg: D3407 Rev: E		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

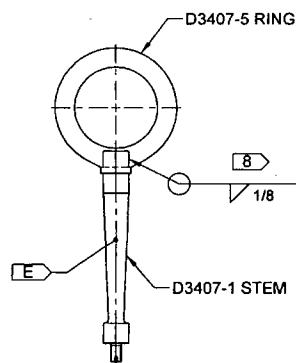
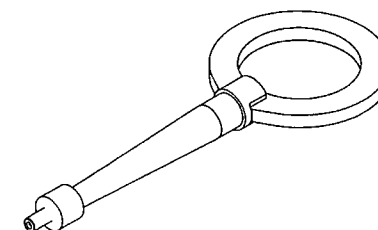
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.063	+/-0.010	.063	/			
1/4-28 UNF	Max: 0.2668 Min: 0.2635	.264	/			
Major Ø	Max: 0.249 Min: 0.2425	.244	/			
Ø0.625	+/-0.010	.625	/			
Ø0.363	+/-0.010	.362	/			
Ø0.750	+/-0.010	.750	/			
R0.100	+/-0.010	R.100	/			
0.470	+/-0.010	.470	/			
0.250	+/-0.010	.250	/			
2.555	+/-0.010	2.555	/			
3.305	+0.000/-0.010	3.300	/			
4.325	+/-0.010	4.325	/			
0.150	+/-0.010	.150	/			
0.550	+/-0.010	.550	/			
0.625	+/-0.010	.625	/			
0.250	+0.010/-0.000	.250	/			

Measured by:	<i>[Signature]</i>	Audited by:	<i>[Signature]</i>	Prototype Approval:	N/A
Date:	09.11.05	Date:	07/11/08	Date:	N/A

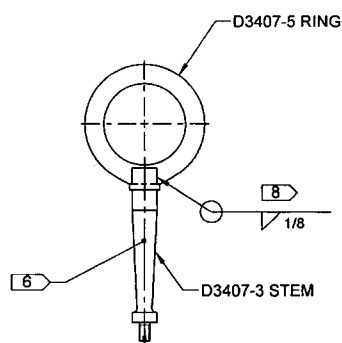
Rev	Date	Change	Revised by	Approved
A	06.11.08	New Issue	KJ/JLM	
B	07.09.26	Tolerances revised	KJ/EC	
C	08.05.14	Dimensions updated per Dwg Rev D	KJ/JLM	
D	08.10.07	Dimensions updated per Dwg Rev E	KJ/DD	<i>[Signature]</i>

QTY -041	QTY -043	QTY -045	PART NUMBER	DESCRIPTION
X			D3407-041	TOW RING
	X		D3407-043	TOW RING
		X	D3407-045	TOW RING
1			D3407-1	STEM
	1		D3407-3	STEM
1	1	1	D3407-5	RING
		1	D3407-7	STEM

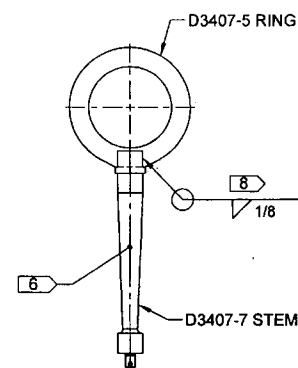
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 53350
BS 09-11-2



D3407-041 TOW RING



D3407-043 TOW RING



D3407-045 TOW RING

RELEASED
07-02-11

NOTES:

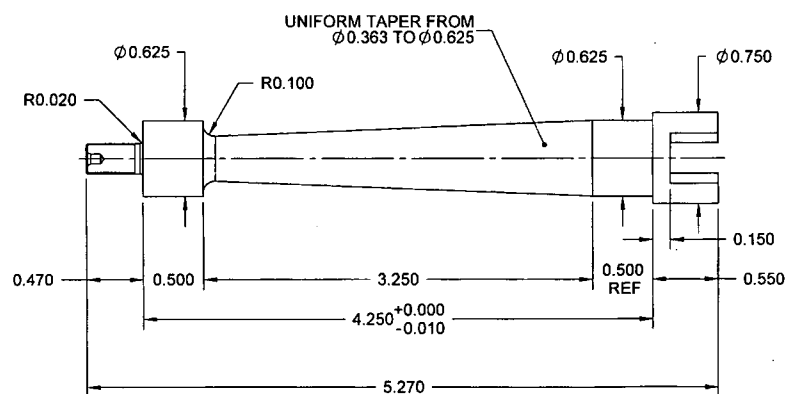
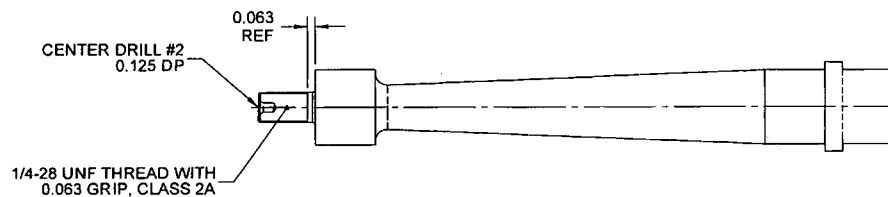
- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3 (EXCEPT THREADS)
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3407-XXX" USING BLACK FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: D3407-041 - 0.60 lbs, D3407-043 - 0.53 lbs, D3407-045 - 0.61 lbs
- 8) WELD PER DART QSI 004 ON ALL EDGES BETWEEN STEM AND RING

E	ADD D3407-045 (ZN B2-1, D8-1); ADD D3407-7 (ZN B6-5); REVISED NOTE 8 TO ADD IDENTIFICATION (ZN A5-1); REASON: PRODUCTION FACILITY	PH	08.07.23
D	D3407-1/3 SLOT WAS ROUND NOW FLAT FOR ASSEMBLY WITH D3407-5 (ZN C2-2, C2-3); D3407-5 WAS ROUND NOW FLAT ON ONE END FOR ASSEMBLY WITH D3407-1/3 (ZN B6-4); REASON: PRODUCTION FACILITY	PH	08.04.07
C	-1/3 LONGER FOR FIT W/WASHER	CP	05.09.09
B	UPDATE DIAMETER, THREAD CLASS ADDED	CP	05.06.17
A	NEW ISSUE	CP	05.03.16
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.07.23		

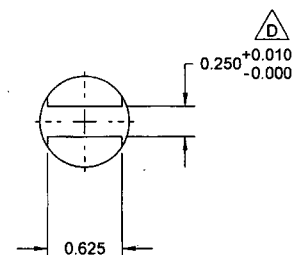
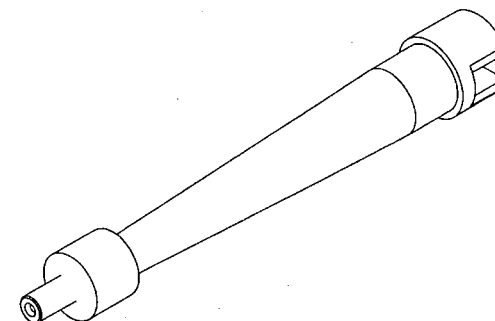
DART AEROSPACE USA, INC.
PORT HADLOCK, WA

DRAWING NO. **D3407** REV. E
SHEET 1 OF 5
TITLE **TOW RING** SCALE NTS

COPYRIGHT © 2005 BY DART AEROSPACE USA, INC.
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS
NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT
WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.



D3407-1 STEM

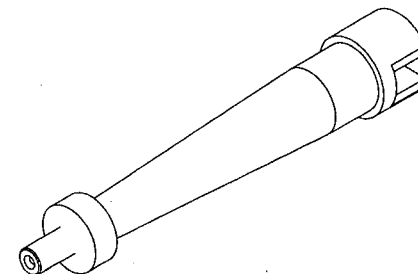


SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 53350

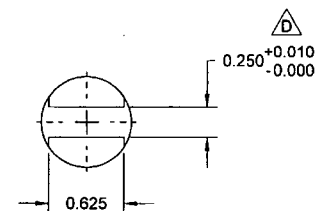
RELEASED
08-07-23

- NOTES:
- 1) MATERIAL: 17-4 PH SS ROUND BAR PER AMS 5643 (REF. DART SPEC M17-4-R)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: MACHINE ALL INSIDE EDGES WITH A 0.010 RADIUS
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.33 lbs

DESIGN	<i>HP</i>	DART AEROSPACE USA, INC.	
DRAWN	<i>HP</i>	PORT HADLOCK, WA	
CHECKED	<i>HP</i>	DRAWING NO.	REV. E
MFG. APPR.	<i>HP</i>	D3407	SHEET 2 OF 5
APPROVED	<i>HP</i>	TITLE	SCALE
DE APPR.	<i>HP</i>	TOW RING	NTS
DATE	08.07.23	COPYRIGHT © 2006 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 53350



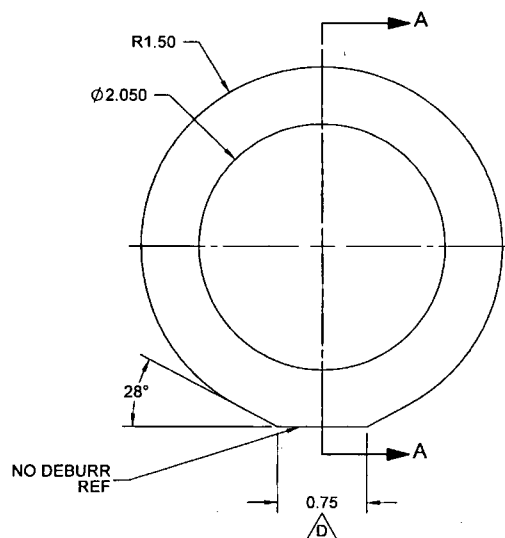
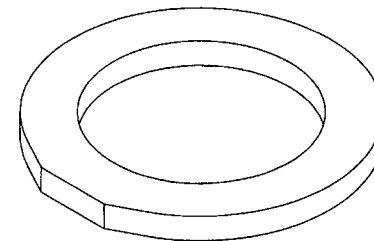
D3407-3 STEM

RELEASED
04-05-01 NPD

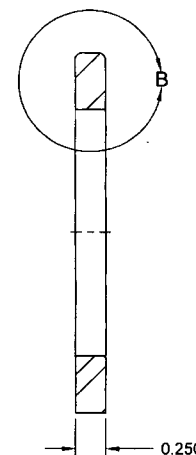
1) MATERIAL: 17-4 PH SS ROUND BAR PER AMS 5643 (REF. DART SPEC M17-4-R)
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: MACHINE ALL INSIDE EDGES WITH A 0.010 RADIUS
6) IDENTIFICATION: N/A
7) WEIGHT: 0.27 lbs

DESIGN		DART AEROSPACE USA, INC. PORT HADLOCK, WA DRAWING NO. D3407 TITLE TOW RING COPYRIGHT © 2005 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION OF DART AEROSPACE USA, INC.	REV. 1
DRAWN	<i>[Signature]</i>		SHEET 3 OF 3
CHECKED	<i>[Signature]</i>		SCALE
MFG. APPR.	<i>[Signature]</i>		NTS
APPROVED	<i>[Signature]</i>		
DE APPR.	<i>[Signature]</i>		
DATE	08.07.23		

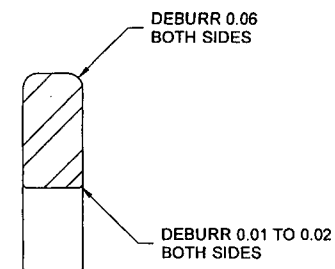
SHOP COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 53350



D3407-5 RING



SECTION A-A

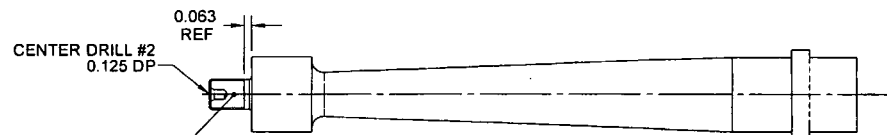


DETAIL B
 SCALE 2X

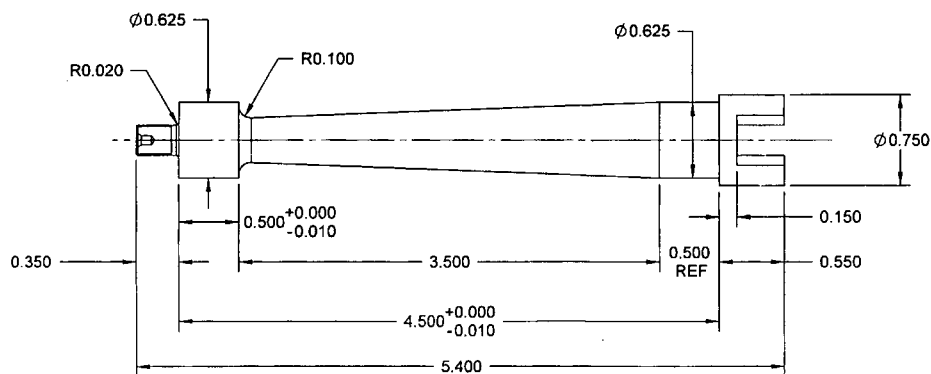
RELEASED
 08-07-23

- NOTES:**
- 1) MATERIAL: 17-4 PH SS BAR PER AMS 5604/5643 (REF. DART SPEC M17-4-B)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.27 lbs

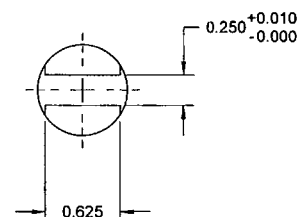
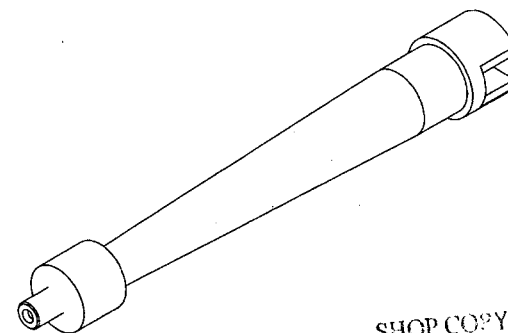
DESIGN	92	DART AEROSPACE USA, INC.	
DRAWN	JE	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D3407	SHEET 4 OF 5
APPROVED		TOW RING	SCALE
DE APPR.			NTS
DATE	08.07.23	<small>COPYRIGHT © 2005 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	



1/4-28 UNF THREAD WITH
0.063 GRIP, CLASS 2A








D3407-7 STEM



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 53350

RELEASED

- NOTES:
- 1) MATERIAL: 17-4 PH SS ROUND BAR PER AMS 5643 (REF. DART SPEC M17-4-R)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: MACHINE ALL INSIDE EDGES WITH A 0.010 RADIUS
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.34 lbs

DESIGN	AJS	DART AEROSPACE USA, INC.	
DRAWN		PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D3407	SHEET 5 OF 5
APPROVED		TITLE	SCALE
DE APPR.		TOW RING	NTS
DATE	08.07.23	COPYRIGHT © 2005 BY DART AEROSPACE USA, INC.	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.			